



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3910-3

Job Sheet 194364



Due
21
9-00

Part No: D3910-3

Job Qty: 15 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: ~~6/7/19~~ 05/06/2019

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	15 pcs	6/7/19	6/7/19	0.00	0.00	Purchasing - 1	5	MAY 06 2019
							Purchasing - 2	5	
							Purchasing - 3	5	
120	Packaging 2-1 - Receive - B4B	15 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 2 - 1 - B4B		MAY 06 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S178137



Part: D3910-3

Job No: 194364

Serial No/Batch: S178137

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/06/19

				0.00 0.00	Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130 QC 6	15 pcs	6/7/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
180 Packaging 3-1 - Stock - B4B	15 pcs	6/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	5+523 MAY 13 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	15 pcs	6/7/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (Purchasing) ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach
 130 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

10HB043348 x 100 

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	1.8750 ft (.125 ea)	110-Purchasing	5178135
D3910-3P	Crosstube Lug	15 pcs (1 ea)	110-Purchasing	5178134

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	2	355	0
	D3910-3P	15	0	0

Part Specifications

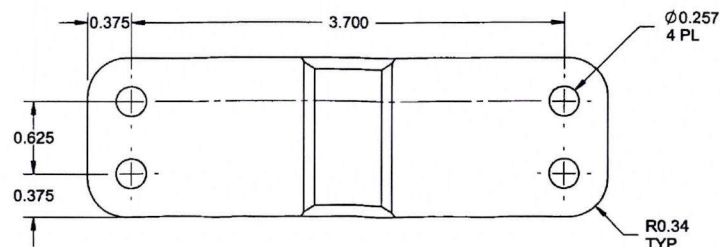
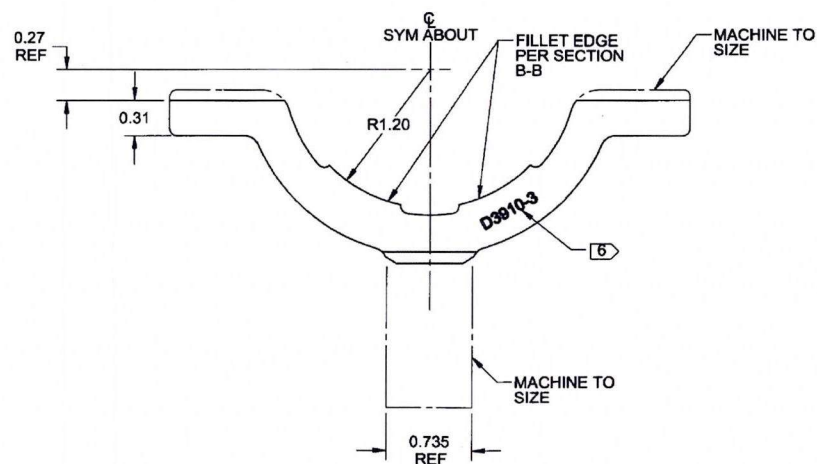
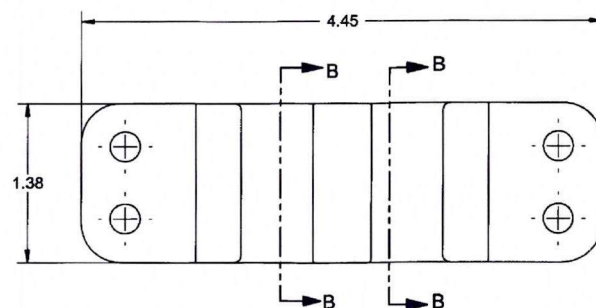
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches ± 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches ± 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches ± 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees ± 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches ± 0.030	1.440 1.380	Reference	

Plex 5/1/19 10:20 AM Dart.lajeunesse.marie



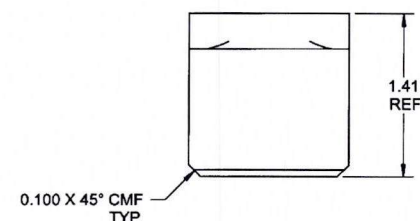
ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194364M15
19-0581



RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO. D3910	REV. E
MFG. APPR.	[Signature]	TITLE X-TUBE LUG (350)	SHEET 3 OF 5
APPROVED	[Signature]	SCALE NTS	
DE APPR.	[Signature]		
DATE	14.05.16		

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043348



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043348

PO Date: 5/1/19

Due Date: 5/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194364	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	5/6/19	75 pcs	0 pcs	75 pcs	\$17.40/pcs	\$1,305.00
							75 x	MAY 06 2019					
2	194407	D3910-5P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	5/6/19	36 pcs	0 pcs	36 pcs	\$17.40/pcs	\$626.40
							36 x	MAY 06 2019					
3	194409	D3910-7P			Crosstube Lug : Various STC's As Per Dwg. D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	5/6/19	100 pcs	0 pcs	100 pcs	\$17.40/pcs	\$1,740.00
							100 x	MAY 06 2019					
Grand Total:													\$3,671.40

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043348



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 5/2/19 8:50 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25161
Shipment Date: 03-May-2019
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577

Terms: Net 60 Days

----- Quantity -----								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
1	75	75 ✓	0	0	EA	D3910-3P Crosstube Lug alodined and painted as per QSI005 Order No: 3785 Order Date: 05/01/19 PO Number: POHB043348 ✓	E	3785-01
2	36	36 ✓	0	0	EA	D3910-5P Crosstube Lug, alodined and painted as per QSI 005 Order No: 3785 Order Date: 05/01/19 PO Number: POHB043348 ✓	E	3785-02
3	100	100 ✓	0	0	EA	D3910-7P Crosstube Lug alodined and painted as per QSI 005 Order No: 3785 Order Date: 05/01/19 PO Number: POHB043348 ✓	E	3785-03
4	15	15 ✓	0	0	EA	D3910-3P Crosstube Lug alodined and painted as per QSI005 Order No: 3702 Order Date: 04/03/19 PO Number: PO043091 ✓	E	3702-04

RECEIVED

MAY 03 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

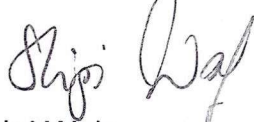
Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
75 ✓	D3910-3 ✓	Cross Tube Lug	E	S141186	018609-1	43348 ✓
15 ✓	D3910-3 ✓	Cross Tube Lug	E	S141186	018609-1	43091 ✓
36 ✓	D3910-5 ✓	Cross Tube Lug	E	B101186	017184-1	43348 ✓
100 ✓	D3910-7 ✓	Cross Tube Lug	E	S141186	017832-1	43348 ✓

MATERIAL: supplied by DART

DAS
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9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 3, 2019